

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006595**Date Inspected:** 28-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Zhi jiang/SunWei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans Quality Assurance (QA) Inspector, Lonnie Whitehead, was present during the times noted above for observations relative to the work being performed.

BAY#3

This QA Inspector observed the following work in progress:

F.C.A.W. welding for weld joint number 044 and on FB015-032. Welder is identified as 044830. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the applicable WPS.

Fit up and S.M.A.W. tack welding of the stiffeners for weld joint numbers 006 and 018 on FB 004-042. Verified joint fit up of components. Welder is identified as 207292. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the applicable WPS.

BAY#2

F.C.A.W. welding for weld joint number 114 on 1AW-seg1. Welder is identified as 045280. ZPMC QC is identified as Li Tan Hua. The welding variables recorded by QC appeared to comply with the applicable WPS.

LAYDOWN YARD

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This QA inspector verified that the following Deck Plates had been completed and the required non destructive testing(NDT) had been performed. Green tags were issued by American Bridge/Flour(ABF).

Component Segment Green Tag#

DP389-001 8AE 7355

DP308-001 8AE 7356

DP364-001 8CE 7347

DP536-001 8CW 7357

DP335-001 8AE 7358

DP174-001 8BW 7359

BAY#11

This QA inspector witnessed the lot testing of the A325 High Strength Bolts to determine the torque values for the minimum tension required. Below is a list of the lots tested and the average torque values determined.

DHGM220021- 543 N.m

DHGM220050- 486 N.m.

DHGM220006- 440 N.m.

DHGM220034- 453 N.m.

DHGM220004- 453 N.m.

DHGM220016- 495 N.m.

DHGM220012- 427 N.m.

DHGM220005- 473 N.m.

DHGM220020- 520 N.m.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By: Whitehead,Lonnie

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer